

Work Order ID 66267

Tuesday, February 08, 2011 11:35:40 AM



Page 1

Item ID: D3535-33

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 2/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 11-02-08 Tooling:

Date:

Run Start



QC:

Date:

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100



FLOW WATER JET

Waterjet

Memo

0.00

11-2-9

FLOW CNC Waterjet

304.0401-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary(6)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

11-2-9

QC

Quality Control

Memo

0.00

120



QC8- Inspect parts - second check

0.00

WJ 11 02 08 6

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 2/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130



Brake NC

NC BRAKE

Brake NC

Memo

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Sulutio

6

(76)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

320

OVEN TEMPERATURE:

FINISH TIME:

400

6. B w-o-ry

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Page 3

Item ID: D3535-33

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Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 2/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

6 4 02 11/02/15

170



Packaging

Packaging

Identify as per dwg & Stock Location

FP-19

0.00

6 BL 11-02-14.

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

OK 11/02/15

MF

11-02-15

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NOTE: Date & initial all entries

Picklist Print

Tuesday, February 08, 2011 11:35:37 AM

Page 1

Work Order ID: 66267



Parent Item: D3535-33



Parent Item Name: Wearshoe

Start Date: 2/9/2011

Required Date: 2/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	149.5538	0.6445	4.070526		13 11-2-9	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	149.5538	
115953	21.6	
116437	52.7538	
116623	75.2	116623

(6)

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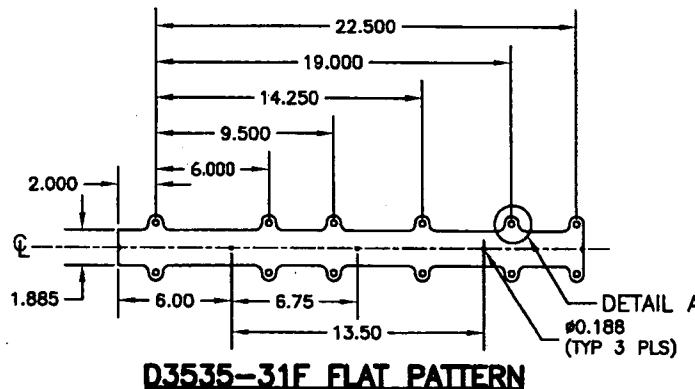
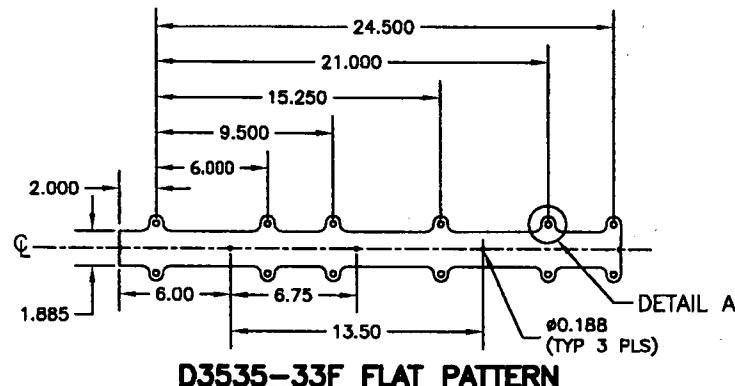
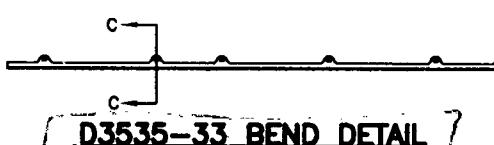
NOTE: Date & initial all entries

DART

DESIGN C.B	DRAWN BY MH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED MH	APPROVED MH	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 4 OF 7 SCALE 1:10

RELEASED
07.04.17
M

66267
**

**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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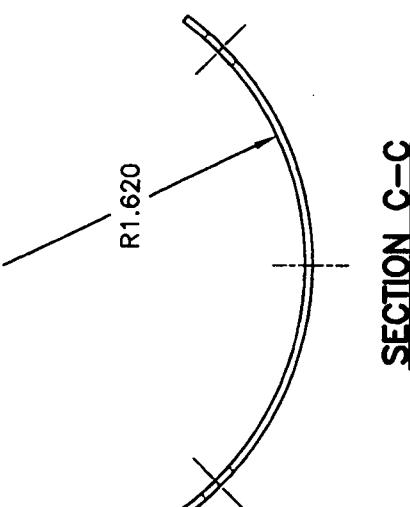
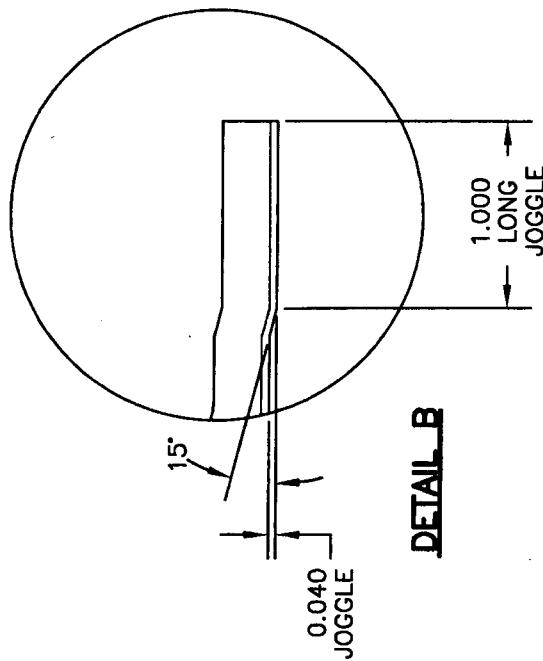
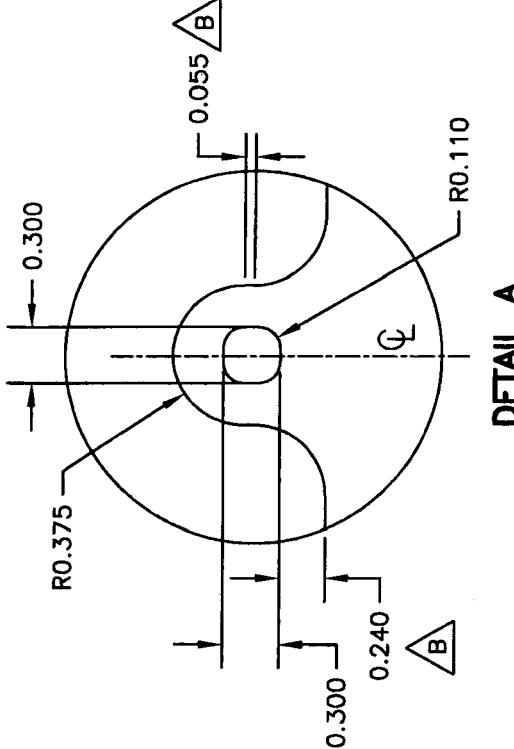
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DART

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:1	

RELEASED

07.04.24 *[initials]**4/20/17*

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DART AEROSPACE LTD	Work Order:	66267
Description: Wearshoe	Part Number:	D3535-33
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>M. M.</u>	Prototype Approval:	N/A
Date:	11-2-09	Date:	11-02-08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.16	New Issue	KJ	

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